F I G. 1

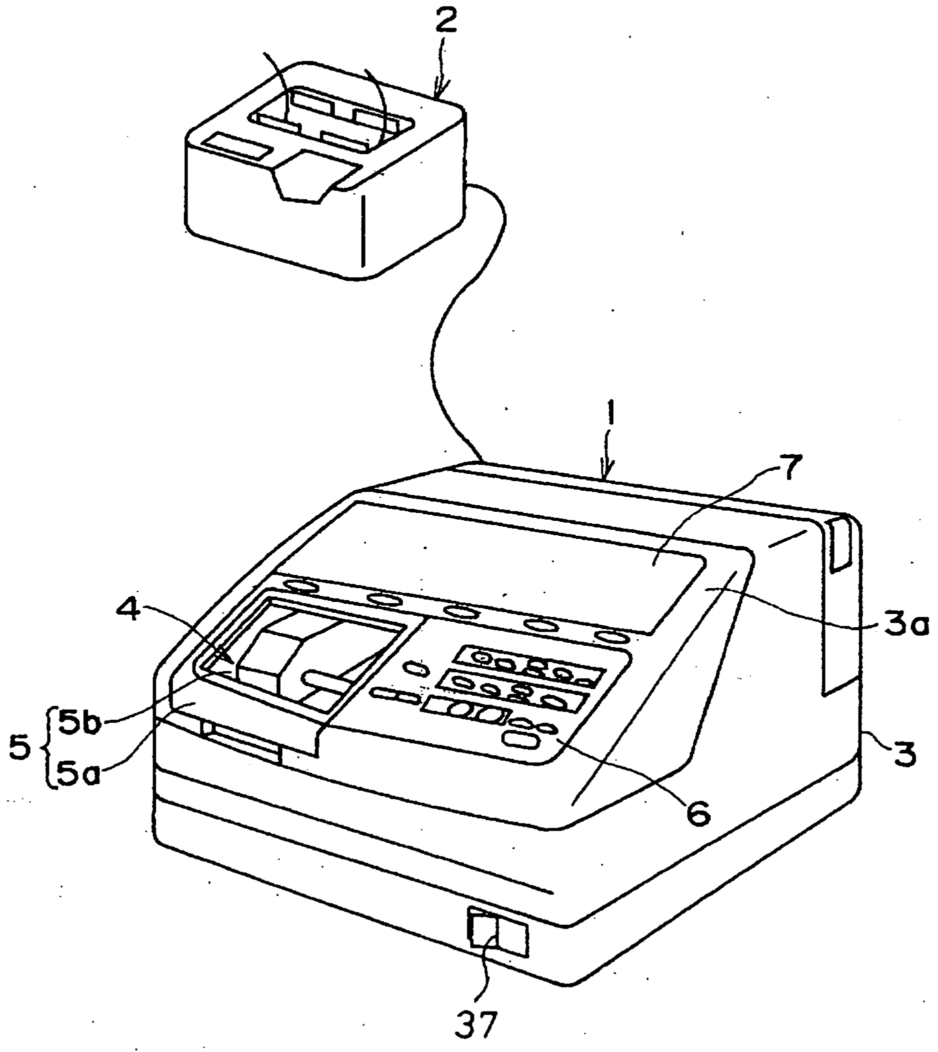
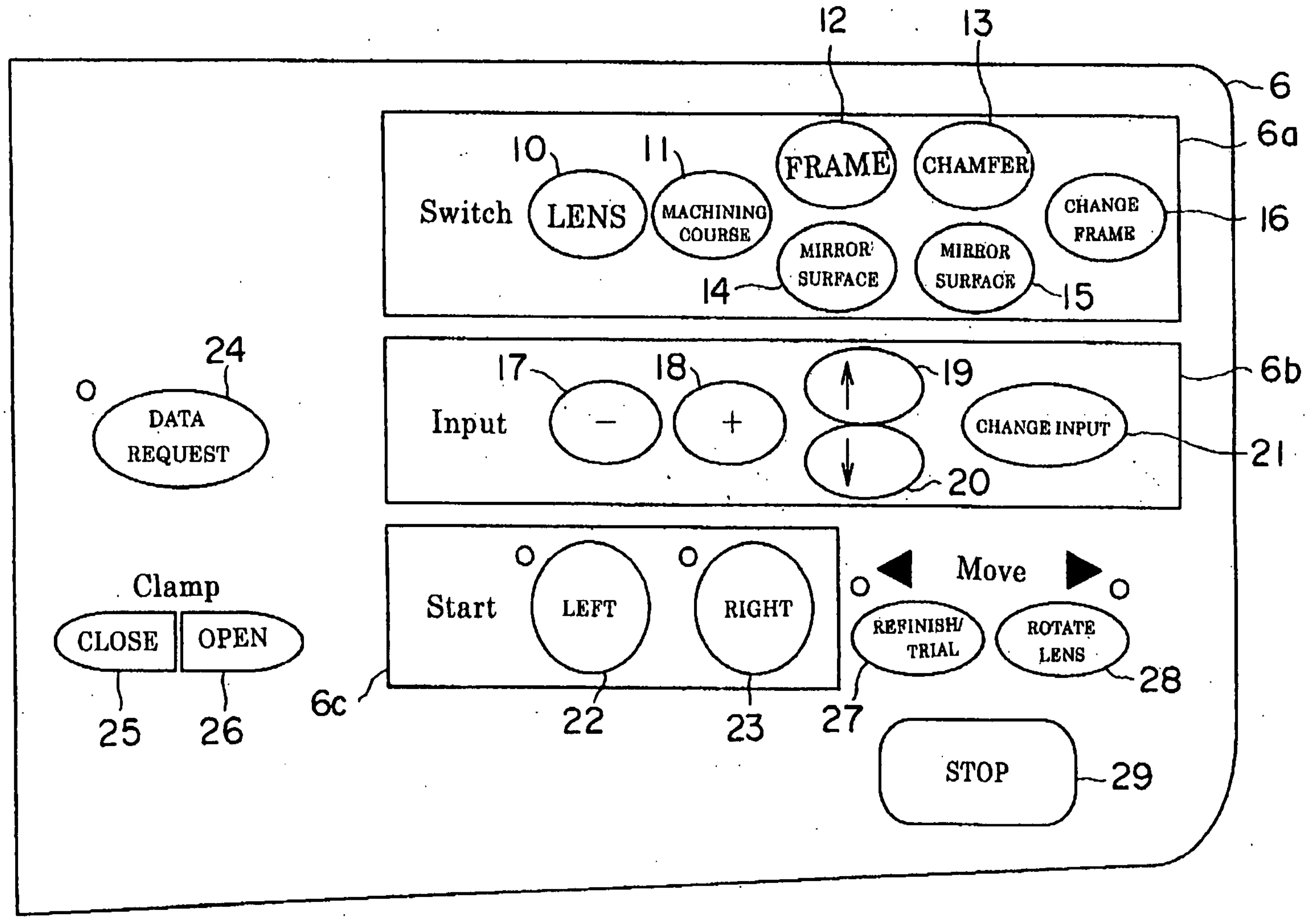


FIG. 2


6
6a
6b
6c
Switch
10
LENS
11
MACHINING COURSE
12
FRAME
13
CHAMFER
14
MIRROR SURFACE
15
MIRROR SURFACE
16
CHANGE FRAME
Input
17
−
18
+
19
20
21
CHANGE INPUT
24
DATA REQUEST
Clamp
CLOSE
OPEN
25
26
Start
LEFT
RIGHT
22
23
Move
REFINISH/ TRIAL
ROTATE LENS
27
28
STOP
29

F I G. 3

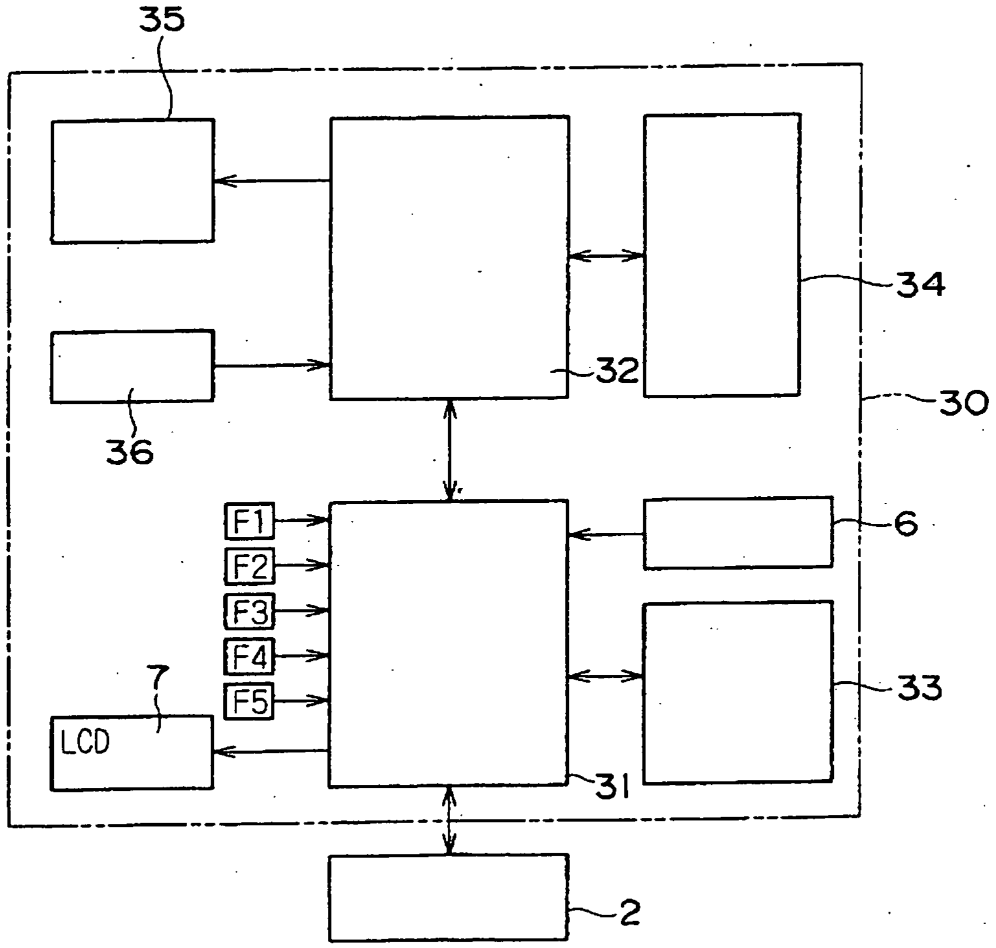


FIG. 4

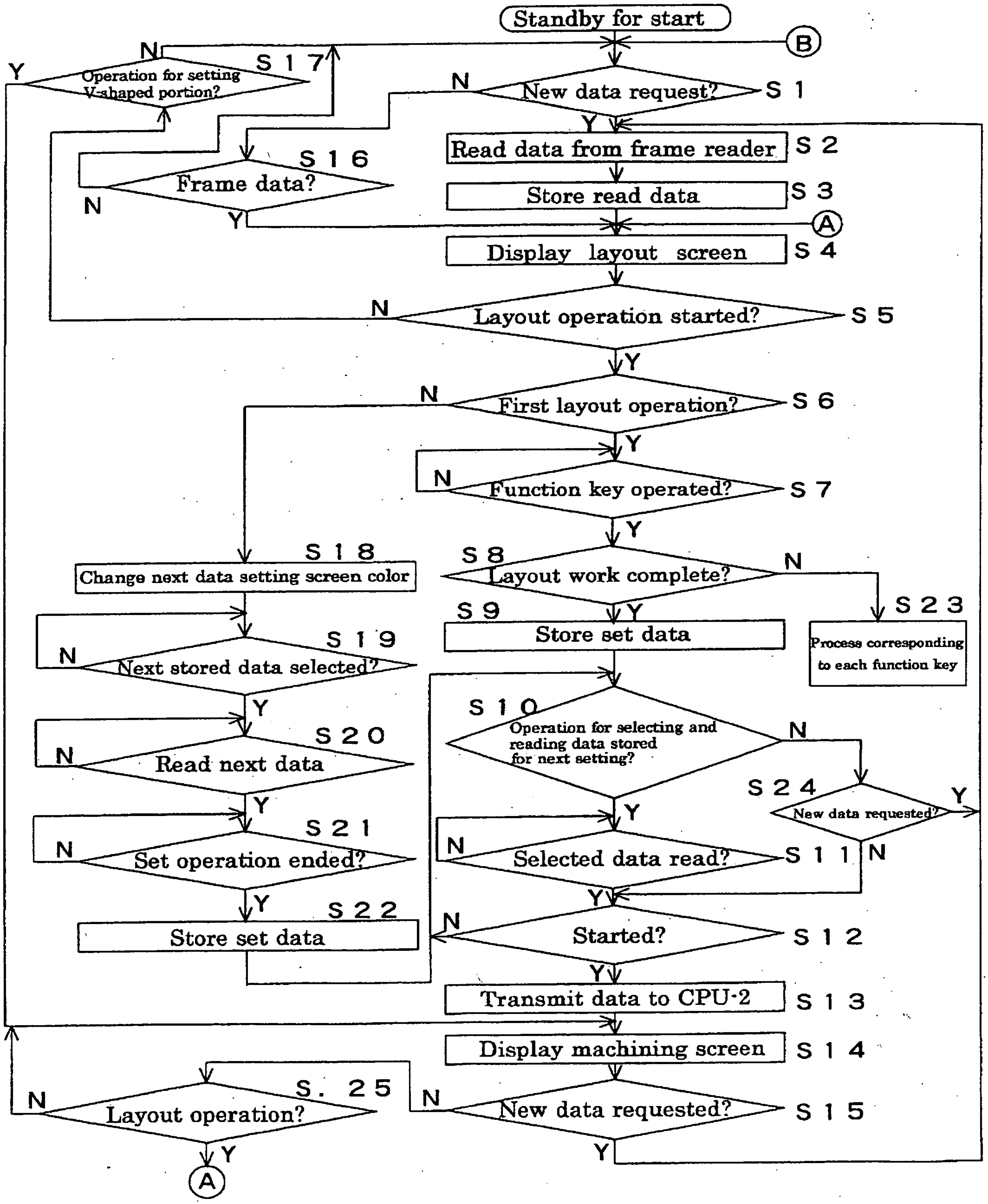

Standby for start
B
New data request?
S 1
N
Y
Read data from frame reader
S 2
Store read data
S 3
A
Display layout screen
S 4
Layout operation started?
S 5
N
Y
First layout operation?
S 6
N
Y
Function key operated?
S 7
N
Y
S 8
Layout work complete?
N
Y
S 9
Store set data
S 23
Process corresponding to each function key
S 10
Operation for selecting and reading data stored for next setting?
N
Y
S 24
New data requested?
Y
N
Selected data read?
S 11
N
Y
Started?
S 12
N
Y
Transmit data to CPU-2
S 13
Display machining screen
S 14
New data requested?
S 15
N
Y
Operation for setting V-shaped portion?
S 17
N
Y
Frame data?
S 16
N
Y
Change next data setting screen color
S 18
Next stored data selected?
S 19
N
Y
Read next data
S 20
N
Y
Set operation ended?
S 21
N
Y
Store set data
S 22
Layout operation?
S. 25
N
Y
A

FIG. 5

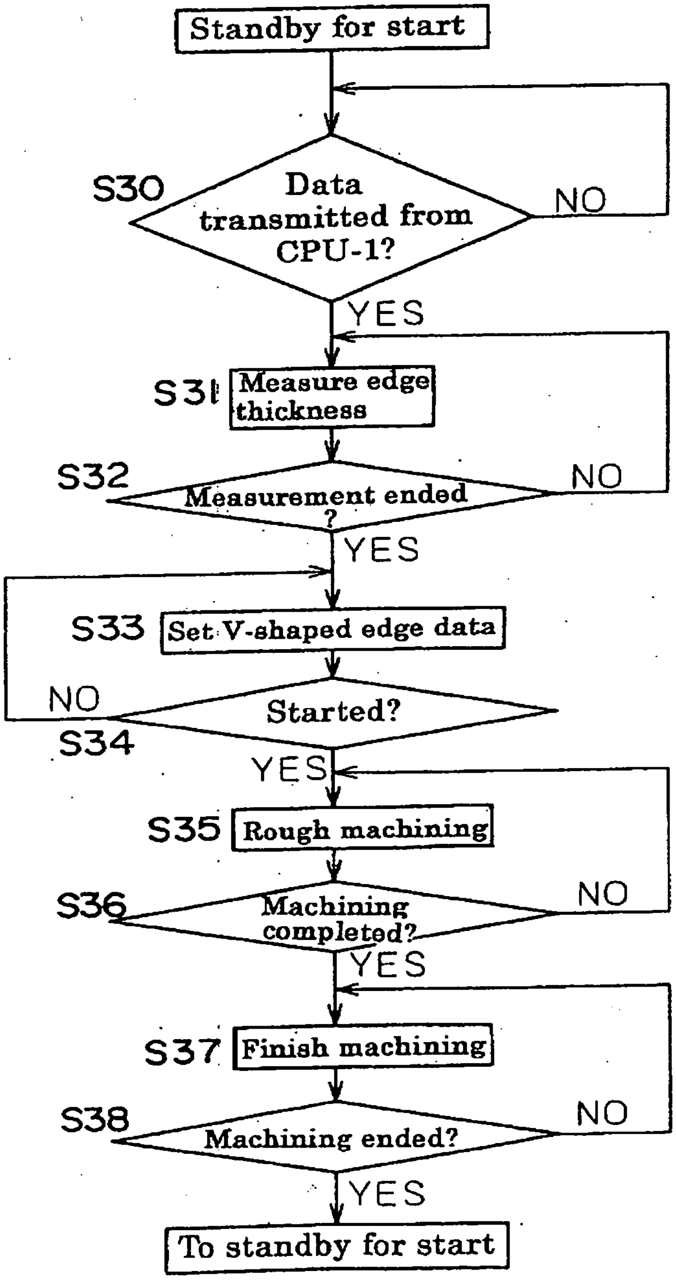

Standby for start
S30
Data transmitted from CPU-1?
NO
YES
S31
Measure edge thickness
S32
Measurement ended ?
NO
YES
S33
Set V-shaped edge data
S34
Started?
NO
YES
S35
Rough machining
S36
Machining completed?
NO
YES
S37
Finish machining
S38
Machining ended?
NO
YES
To standby for start

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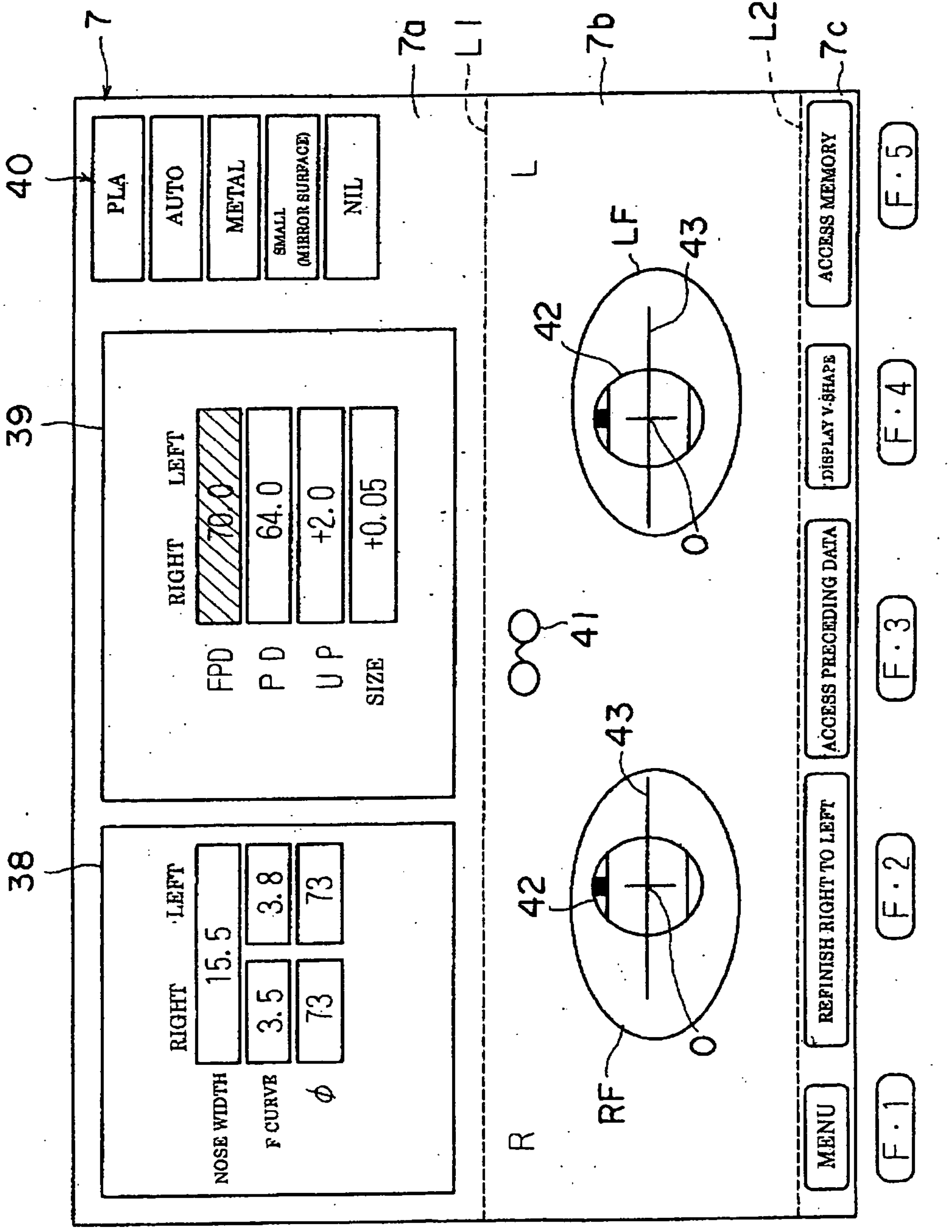
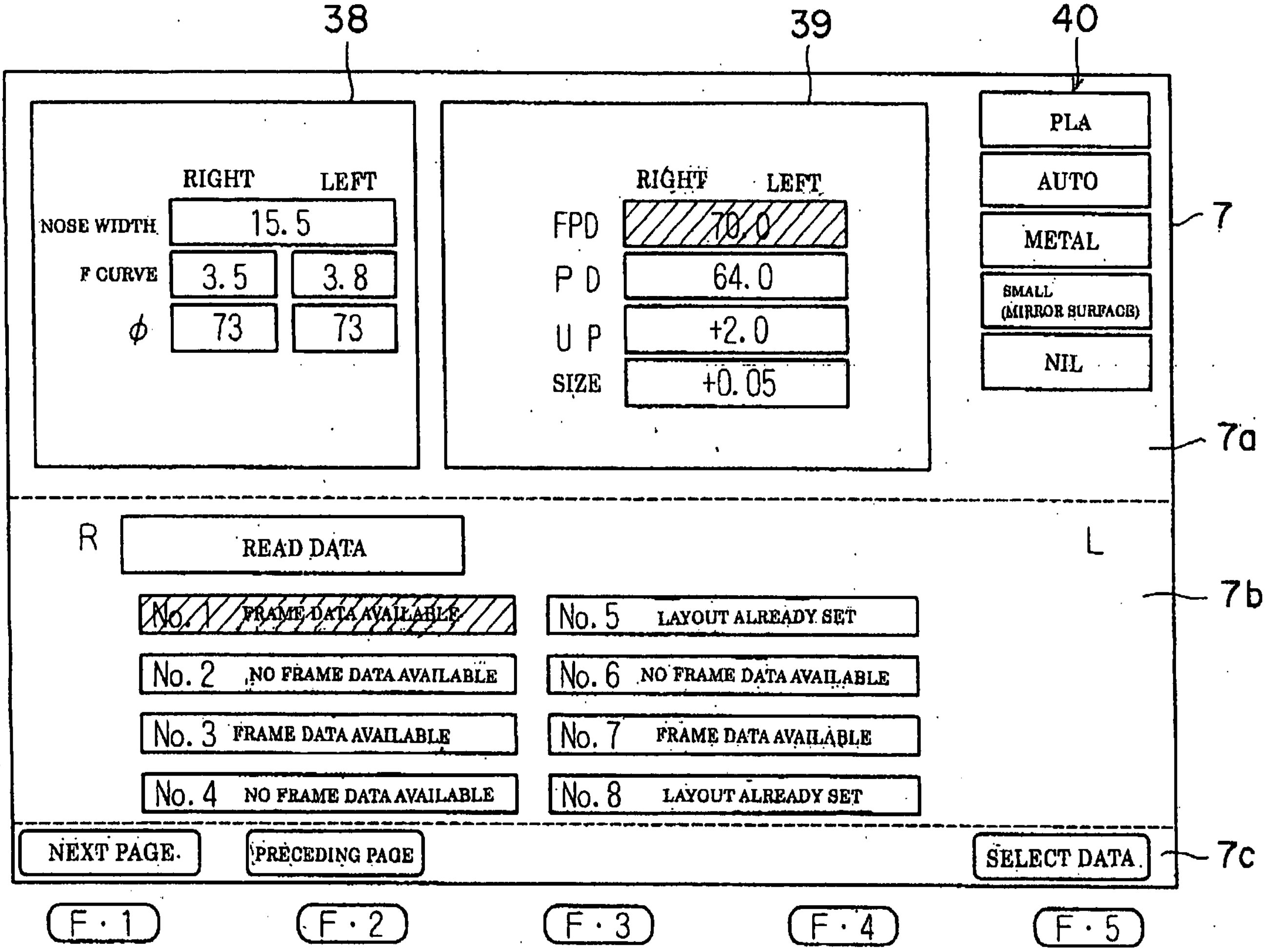
FIG. 6

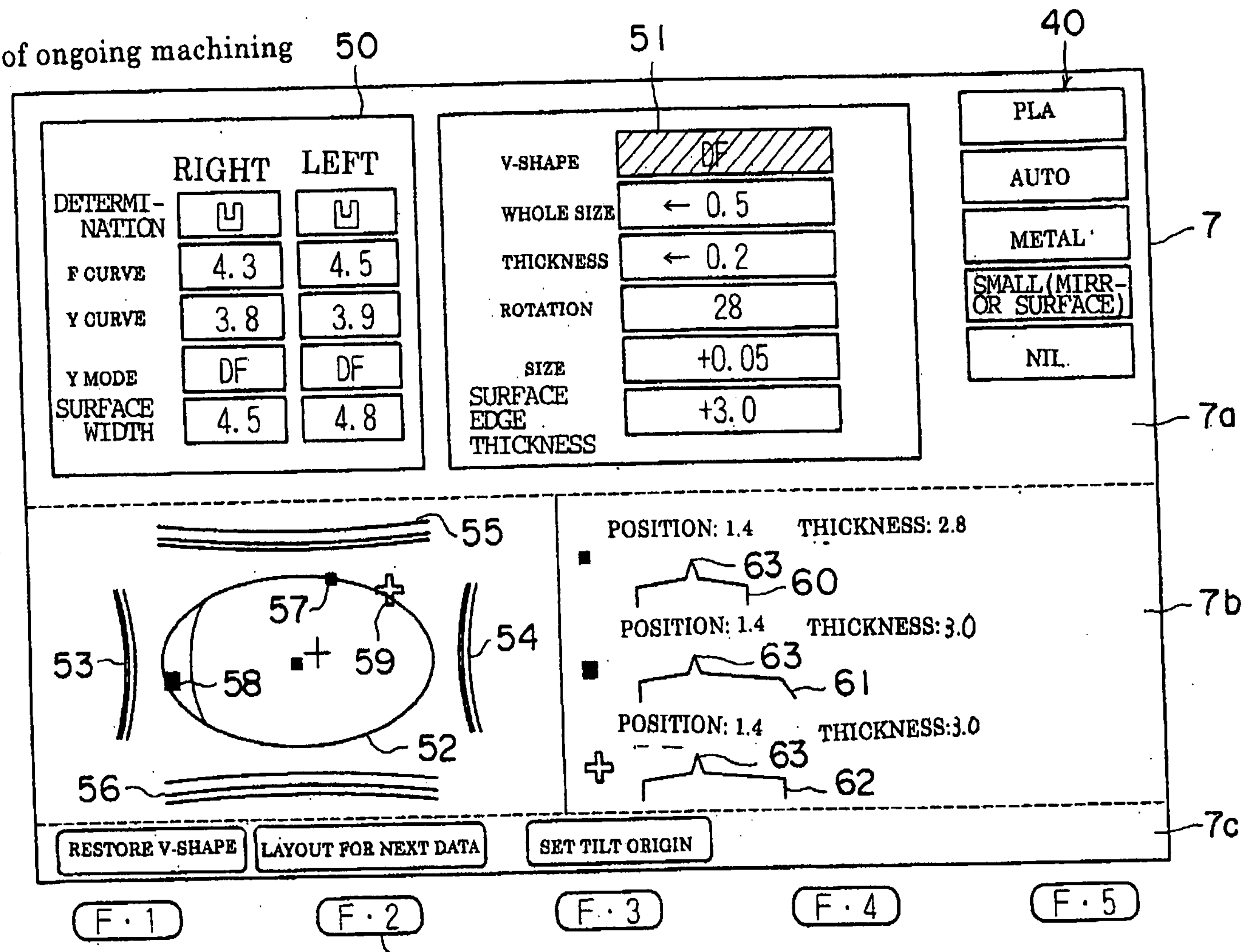


F I G. 7


38
39
40
7
7a
7b
7c
RIGHT
LEFT
NOSE WIDTH
15. 5
F CURVE
3. 5
3. 8
ϕ
73
73
RIGHT
LEFT
FPD
70.0
P D
64. 0
U P
+2. 0
SIZE
+0. 05
PLA
AUTO
METAL
SMALL (MIRROR SURFACE)
NIL
R
READ DATA
L
No. 1 FRAME DATA AVAILABLE
No. 2 NO FRAME DATA AVAILABLE
No. 3 FRAME DATA AVAILABLE
No. 4 NO FRAME DATA AVAILABLE
No. 5 LAYOUT ALREADY SET
No. 6 NO FRAME DATA AVAILABLE
No. 7 FRAME DATA AVAILABLE
No. 8 LAYOUT ALREADY SET
NEXT PAGE
PRECEDING PAGE
SELECT DATA
F · 1
F · 2
F · 3
F · 4
F · 5

F I G. 8

Screen of ongoing machining



	RIGHT	LEFT
DETERMINATION	⊔	⊔
F CURVE	4.3	4.5
Y CURVE	3.8	3.9
Y MODE	DF	DF
SURFACE WIDTH	4.5	4.8

V-SHAPE	DF
WHOLE SIZE	← 0.5
THICKNESS	← 0.2
ROTATION	28
SIZE	+0.05
SURFACE EDGE THICKNESS	+3.0

POSITION: 1.4 THICKNESS: 2.8

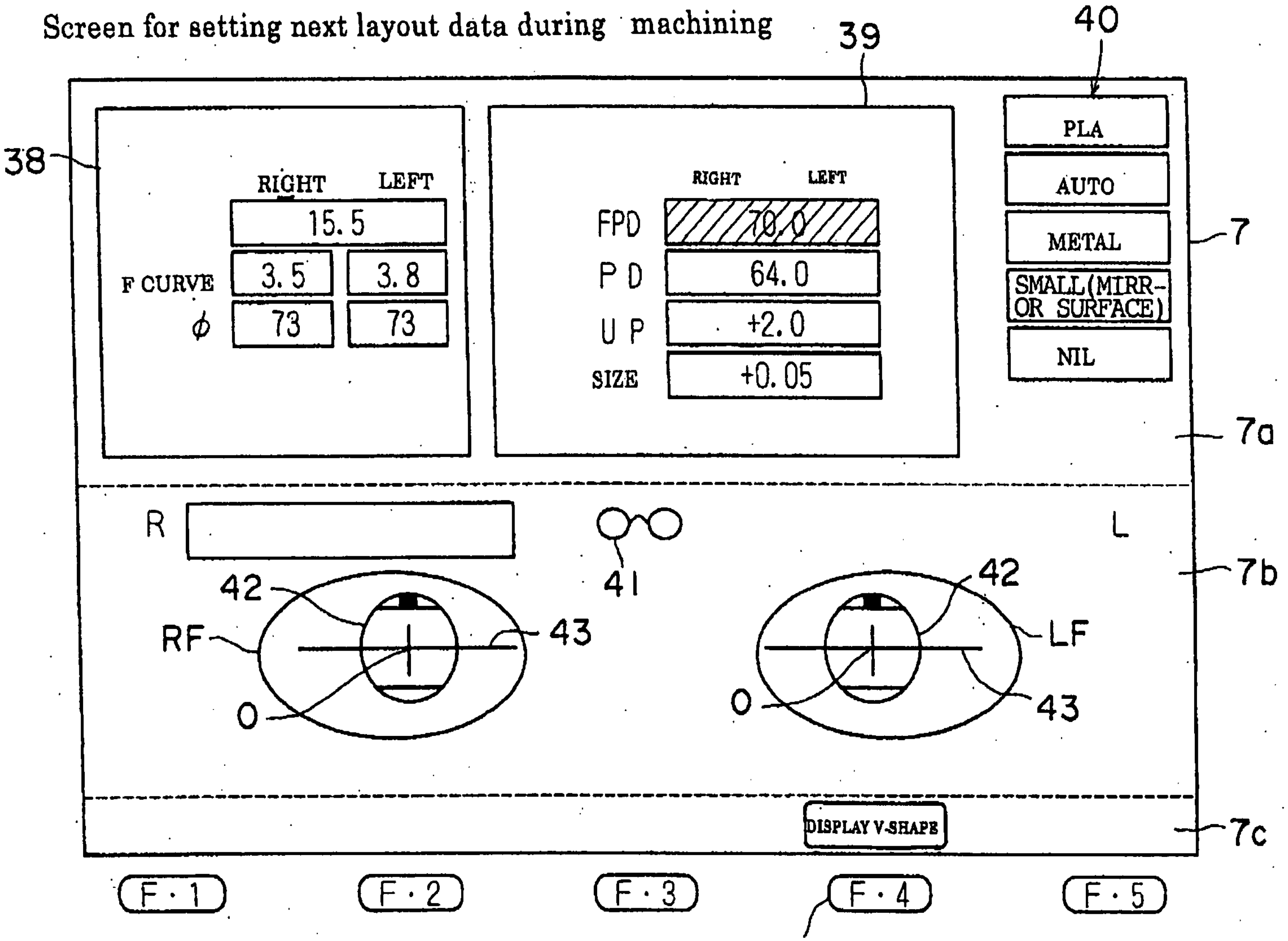
POSITION: 1.4 THICKNESS: 3.0

POSITION: 1.4 THICKNESS: 3.0

DEPRESS FOR PERMITTING NEXT DATA LAYOUT TO BE SET DURING MACHINING

F I G. 9

Screen for setting next layout data during machining

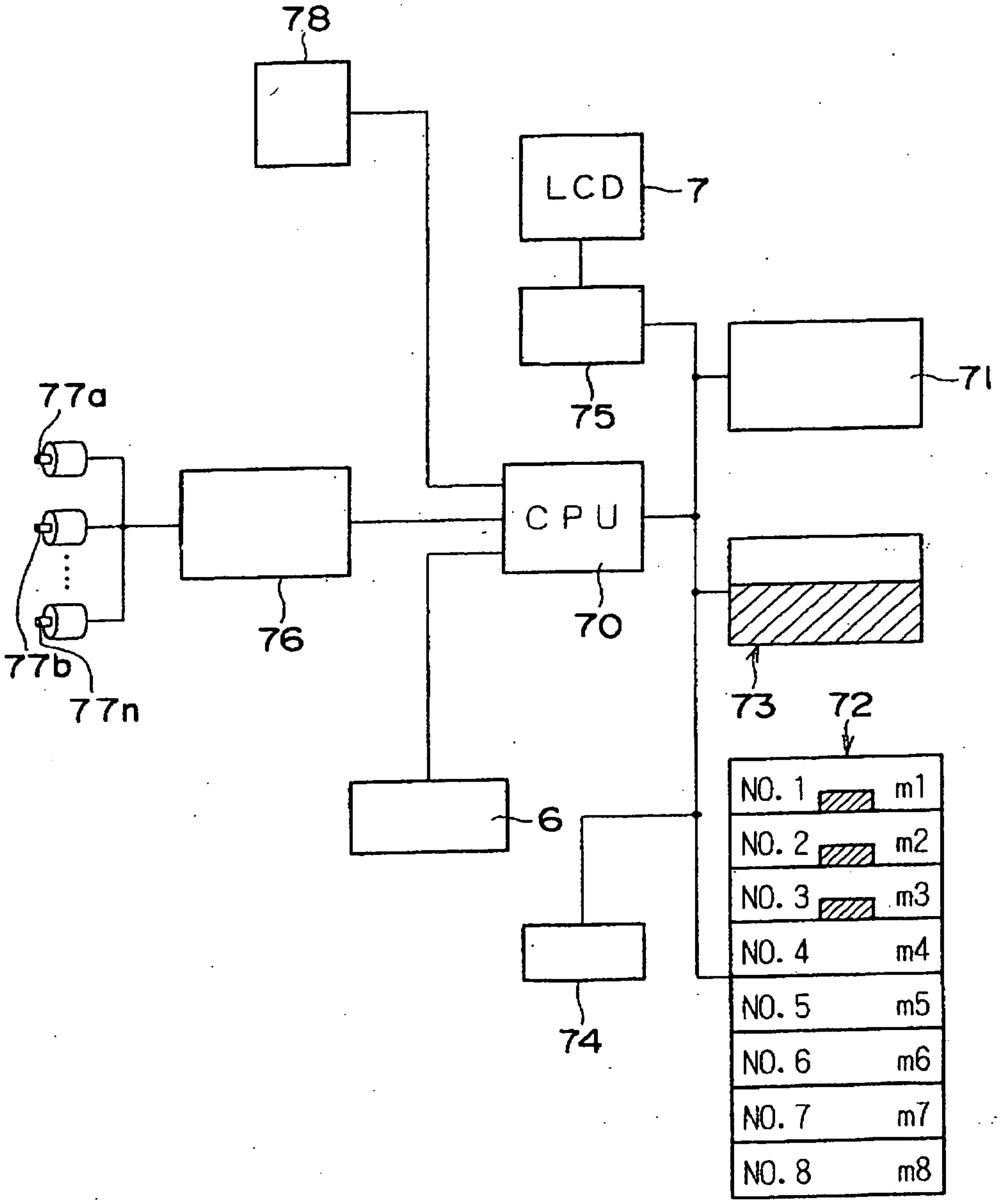


	RIGHT	LEFT
	15.5	
F CURVE	3.5	3.8
φ	73	73

	RIGHT	LEFT
FPD	70.0	
P D	64.0	
U P	+2.0	
SIZE	+0.05	

RESTORE ORIGINAL V-SHAPE SETTING SCREEN

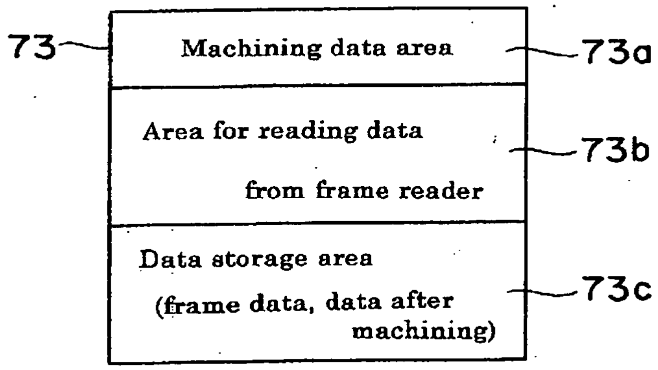
F I G. 10



NO. 1 ▨	m1
NO. 2 ▨	m2
NO. 3 ▨	m3
NO. 4	m4
NO. 5	m5
NO. 6	m6
NO. 7	m7
NO. 8	m8

FIG. 11

Example of memory area allocation



F I G. 12

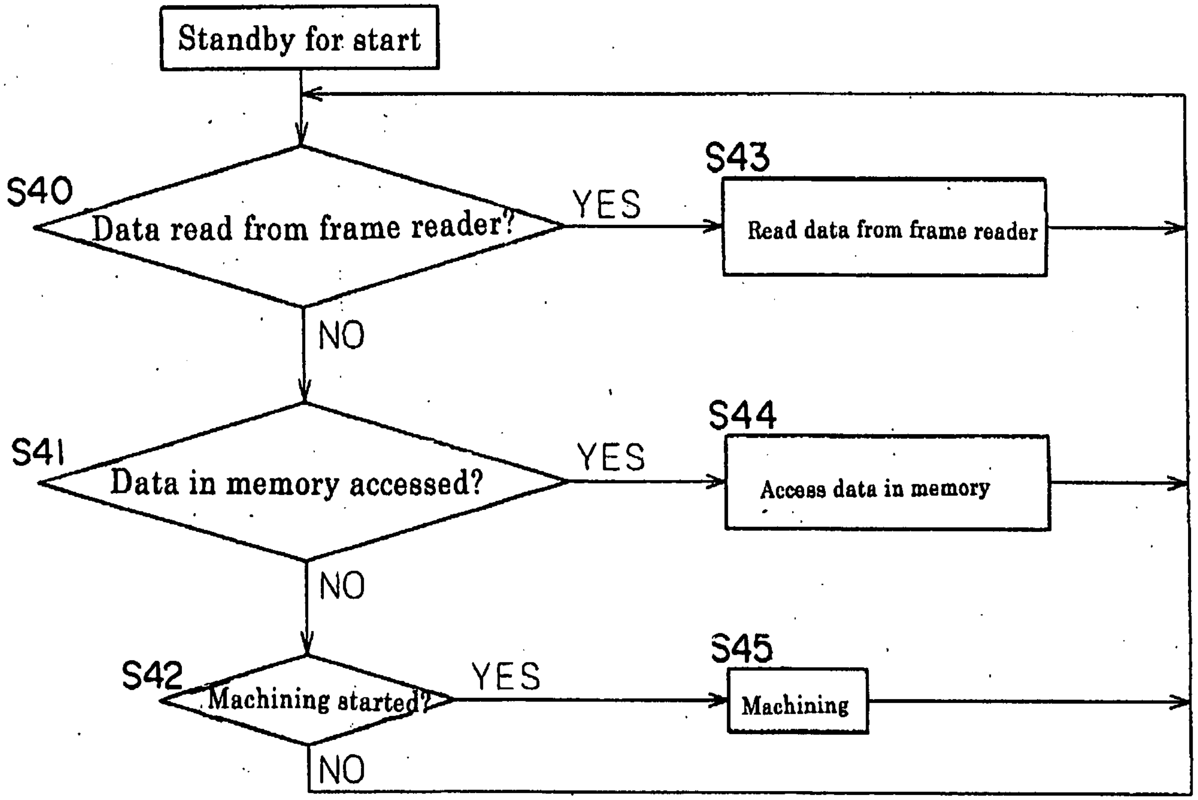

Standby for start
S40
Data read from frame reader?
YES
NO
S43
Read data from frame reader
S41
Data in memory accessed?
YES
NO
S44
Access data in memory
S42
Machining started?
YES
NO
S45
Machining

FIG. 13

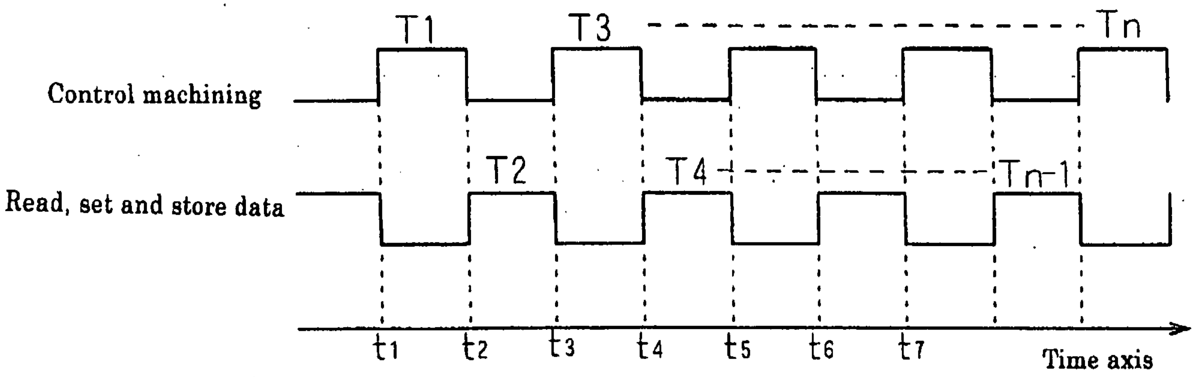
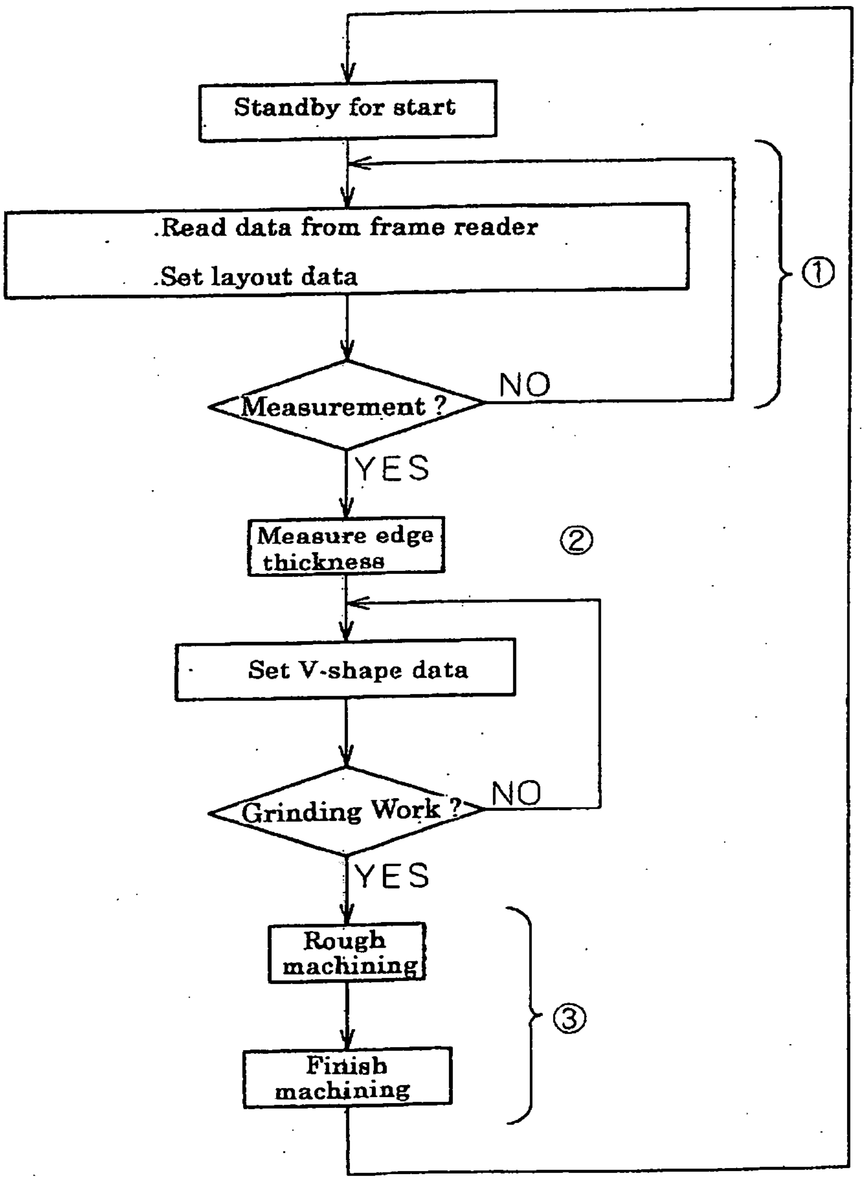

T1
T3
Tn
Control machining
T2
T4
Tn-1
Read, set and store data
t1
t2
t3
t4
t5
t6
t7
Time axis

FIG. 14


Standby for start
.Read data from frame reader
.Set layout data
Measurement ?
NO
YES
①
Measure edge thickness
②
Set V-shape data
Grinding Work ?
NO
YES
Rough machining
Finish machining
③